

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005802**Date Inspected:** 21-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 630**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Shi Lei, Chen Likun and Le Li			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Assembly, Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Joe Alaniz was present during the times noted above for observations relative to the work being performed.

Bay 11

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 25% of the area previously tested by ZPMC MT personnel. This QA Inspector generated a TL-6028 MT report on this date. The weld designation numbers is as follows:

WSD1-SA209C/D:

1, 8, 9, 16, 17 and 24

This QA Inspector signed green tag #5625 for Skin D Connection plate stiffeners along with ZPMC and ABF QC, after verification of visual and non destruction testing of all three parties.

This QA Inspector observed the following work in progress:

Bay 10

ZPMC's qualified welding personnel's identified as Mr. Dai Yunhe (040586), Mr. Zang Weili (040570) and Mr. Ge Gmochang (053469) perform SMAW welding on weld joints identified SSD1-FBSA3-1E/E-45A, 22 and 59. ZPMC QC identified Mr. Chen Likun was present to monitor the welding process. The welding parameters as

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2312 and WPS-B-T-2212.

ZPMC's qualified welding personnel's are identified as Mr. Yu Chaoye (053869) and Mr. Ni Xiuba (040533) perform FCAW (repair) welding on weld joint identified as Skin C and Skin D on North Tower. ZPMC QC identified Mr. Chen Ying Xin was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-FCAW-36-3F-Repair.

ZPMC welding personnel Mr. Yun Chuanjin (0503060) performing groove welding of weld joint SSD1-FCA3-1B/C-12, 13, 14 and 16. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Shen Fu You and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221B-43C-S-2.

Bay 11

ZPMC welding personnel Mr. Xue Yian (040759) performing groove welding of weld joint ESD1-FBSAB-24A/C-10, 14, 19 and 23. The personnel were observed welding in the 1G (flat) position utilizing a Submerged Arc Welding (SAW) process. ZPMC QC identified Mr. Li Ming and was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2321-B-P3-S-2.

ZPMC's qualified welding personnel's are identified as Mr. Ma Yusheng (040759) and Mr. Xu Hua (049220) perform FCAW welding on weld joint identified as ED1-A29A/B-24 and 25. ZPMC QC identified Mr. Le Li was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F.

Bay 13

ZPMC qualified welding personnel identified as Mr. Zhang Jihua (066482) perform SMAW welding on weld joints identified FB051-063. ZPMC QC identified Mr. Shi Lie was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2114-FCM.

Bay 14

ZPMC's qualified welding personnel are identified as Mr. Li Jun (051348) perform SMAW tack welding (repair work) on weld joint identified as 1AW SEG003*-003-006 and SEG004*-003-006. ZPMC QC identified Mr. Shi Lei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-U2a-F-3 (CWR BWR3110).

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
